

Thursday, 31/07/2008 12:18:19 PM
Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLANGE ASS'Y
 Job Number : 40856
 Estimate Number : 13032
 P.O. Number :
 This Issue : 31/07/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3651043
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3651 REV.B
 Previous Run : 39935 Drawing Revision : B
 Material :
 Due Date : 07/08/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC
 Est Rev:B ECN 1113P 08-01-22 DD
 Est Rev:C ecn1162 08-04-02 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.2573 sf(s)/Unit Total : 1.0290 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 108415 HB 8-8-13

(FOR D3651-7)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651 (D3651-7)

Dwg Rev: B

Prog Rev: B

HB 8-8-13

⑥

2-Deburr if necessary
 IDENTIFY AS D3651-7

HB 8-8-13

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-8-13

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/08/13 HB

day, 31/07/2008 12:18:19 PM

Lecocq

Process Sheet

er: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASSY

umber: 40856

Part Number: D3651043

ber:



eq. #:

Machine Or Operation:

Description :

5.0

M304S26GA

304/316 0.018 SHEET



Comment: Qty.: 0.2573 sf(s)/Unit Total: 1.0290 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 165591 HB 8-8-14

(FOR D3651-5)

6.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651 (D3651-5)

Dwg Rev: HB

Prog Rev: HB

HB 8-8-14

(6)

2-Deburr if necessary

Identify as D3651-5

HB 8-8-14

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-8-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

HB 8-8-14

(6)

9.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3651-5 and D3651-7 as per Dwg D3651

HB 08/09/24

(6)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

HB 08/09/24

(6)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3651

HB 08-09-25

(6)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASS'Y

Job Number: 40856

Part Number: D3651043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-25 (12)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/08/05 (16)

14.0

D36513

Base



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

BASE

B37165 (3)

B41983

SB 08/09/30

15.0

MS20427M33

Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s)

Rivet

109371

FF 08/10/02

16.0

MS210603K

Nut Plate



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Nut Plate

108456 x 46 mm, 109371 x 18 mm

17.0

CR3523401

RIVET



Comment: Qty.: 57.0000 Each(s)/Unit Total: 228.0000 Each(s)

RIVET

1109405 (31)

M108827 (197)

FF 08/10/02

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3651

FF 08/10/02

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/02

(x4)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASSY

Job Number: 40856

Part Number: D3651043

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location:

GA

SB 08/10/02

4
5

21.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/02

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-10-02

Job Completion



8 7 6 5 4 3 2 1

TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)

MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

G
GTAW
GRIND FLAT TO
CLEAR FASTENERS
(2 PLACES)

D3651-5 TOP FLANGE

D3651-7 BOTTOM FLANGE

D3651-5
TOP FLANGE
(REF)

D3651-7
BOTTOM FLANGE
(REF)

D3651-3
BASE

B
8.74
(REF)

11.62
(REF)

0.88 (REF)

D3651-043 FLANGE WELDMENT

QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

RELEASED
08-03-27-14

D3651-043 NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.76 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO. D3651	REV. B
MFG. APPR.	MA	SHEET 2 OF 9	
APPROVED	MA	TITLE AFT BASE ASSEMBLY	SCALE 1:3
DE APPR.	MA	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

